

5/28

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23716
<b>Description:</b> Heli-Utility-Basket, Lightweight		<b>Part Number:</b>	D350-721-041
<b>Drawing:</b>		<b>Qty:</b>	1
Ref: IIN-D350-721 Rev. A page 7,8; D3325 Rev. A page 1		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty																																																																																																								
1	DC	Issue Travelers for: D350-721-041 Utility Basket Assy, LH/RH D3324-041 Basket Base Assembly D3325-041 Basket Lid Assembly <b>Drawing not required</b>																																																																																																											
		Batch 23716 23716 23716																																																																																																											
2	DC	Photocopy bluefile and create labels per PPP D350-721-041 <b>CHG001</b>																																																																																																											
		WK 26																																																																																																											
3	WS	Go to Travelers D3324-041 & D3325-041																																																																																																											
4	GA	<b>Pick: Assembly Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2022-101</td><td>Spacer</td><td>B21505</td></tr><tr><td>1</td><td>D2332-041</td><td>Prop Assembly</td><td>B23560</td></tr><tr><td>1</td><td>D2530</td><td>Handle Assembly</td><td>B21803</td></tr><tr><td>2</td><td>D2535</td><td>Spring</td><td>B27760</td></tr><tr><td>2</td><td>D2537</td><td>Bushing</td><td>B23839</td></tr><tr><td>1</td><td>D2729-1</td><td>Label</td><td></td></tr><tr><td>2</td><td>D2931</td><td>Bumper</td><td>B21131</td></tr><tr><td>1</td><td>D3320-041</td><td>Webbing</td><td>B23538</td></tr><tr><td>1</td><td>D3351-1</td><td>Label</td><td>B23027</td></tr><tr><td>2</td><td>AN3-16A</td><td>Bolt</td><td>M17073</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M16199</td></tr><tr><td>1</td><td>AN4-20A</td><td>Bolt</td><td>M12082</td></tr><tr><td>1</td><td>AN4-22A</td><td>Bolt</td><td>M15382</td></tr><tr><td>4</td><td>AN5-17A</td><td>Bolt</td><td>M16273</td></tr><tr><td>2</td><td>AN960JD416</td><td>Washer</td><td>M16941</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M16154</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M16527</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M10158</td></tr><tr><td>32</td><td>AN960JD9</td><td>Washer</td><td>M16499</td></tr><tr><td>4</td><td>AN970-4</td><td>Washer</td><td>M16895</td></tr><tr><td>32</td><td>MS20600AD4W23</td><td>Rivet</td><td>M18040</td></tr><tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td></td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M15924</td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr><tr><td>4</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M16941</td></tr></table>	Qty	Part Number	Description	Batch	2	D2022-101	Spacer	B21505	1	D2332-041	Prop Assembly	B23560	1	D2530	Handle Assembly	B21803	2	D2535	Spring	B27760	2	D2537	Bushing	B23839	1	D2729-1	Label		2	D2931	Bumper	B21131	1	D3320-041	Webbing	B23538	1	D3351-1	Label	B23027	2	AN3-16A	Bolt	M17073	2	AN4-7A	Bolt	M16199	1	AN4-20A	Bolt	M12082	1	AN4-22A	Bolt	M15382	4	AN5-17A	Bolt	M16273	2	AN960JD416	Washer	M16941	2	AN960JD416L	Washer	M16154	4	AN960JD516	Washer	M16527	2	AN960JD8	Washer	M10158	32	AN960JD9	Washer	M16499	4	AN970-4	Washer	M16895	32	MS20600AD4W23	Rivet	M18040	2	MS20600AD4W3	Rivet		2	MS21042L3	Nut (or -3)	M15924	4	MS21042L4	Nut (or -4)	M15924	4	MS21042L5	Nut (or -5)	M16941			
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5	PK	<b>Pick: Packing Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>3</td><td>D2230-1</td><td>Lug</td><td>B22163C</td></tr><tr><td>4</td><td>D2230-3</td><td>Clamp</td><td>B22121E</td></tr><tr><td>4</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B22594</td></tr><tr><td>1</td><td>D3338-1</td><td>Lug</td><td>B23796</td></tr><tr><td>2</td><td>D3350-041</td><td>Strut</td><td>B22211</td></tr><tr><td>2</td><td>AN4-12A</td><td>Bolt</td><td>M18034</td></tr><tr><td>8</td><td>AN4-13A</td><td>Bolt</td><td>M17406</td></tr><tr><td>4</td><td>AN4-14A</td><td>Bolt</td><td>M14600</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M16941</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr></table>	Qty	Part Number	Description	Batch	3	D2230-1	Lug	B22163C	4	D2230-3	Clamp	B22121E	4	D2856-400-720	Abrasion Strip	B22594	1	D3338-1	Lug	B23796	2	D3350-041	Strut	B22211	2	AN4-12A	Bolt	M18034	8	AN4-13A	Bolt	M17406	4	AN4-14A	Bolt	M14600	24	AN960JD416	Washer	M16941	16	MS21042L4	Nut (or -4)	M15924																																																															
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RELEASED  
11/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23716</b>
<b>Description:</b> Heli-Utility-Basket, Lightweight	<b>Part Number:</b>	<b>D350-721-041</b>
<b>Drawing:</b>	<b>Qty:</b>	<b>1</b>
<b>Ref:</b> IIN-D350-721 Rev. A page 7,8; D3325 Rev. A page 1		<b>Page 2 of 2</b>

Step	Location	Procedure	By	Date	Qty
6	GA	Assemble as per Dwg IIN-D350-721 Attach Travelers: Qty Part Number Description Batch 1 D3324-041 Basket Base Assy 23716 1 D3325-041 Basket Lid Assy 23716	SAD	05/07/27	1
7	QC5	Inspect for foreign objects as per QSI 024 & Assembly work to Step 6	AL	05/07/27	1
8	QC4	Inspect Kit 100% for completeness on the W/O	CL	05/08/04	1
9	PK	Identify and pack for shipping as per PPP D350-721-041 REV. 13	CL	05/08/04	1
10	AC	Cost / part: 1805.46 1805.46	AL	05/09/25	1
11	DC	Close Work Order and Ensure Travelers Attached Inspect Level 21 Travelers: D350-721-041 D3324-041 D3325-041	CL	05/08/05	1

Rev	Date	Change	Revised By	Approved
A	04.11.10	New issue	KJ/JLM	
B	05.02.09	Now made in-house	KJ/JLM	
C	05.03.02	Added D3338-1 & D3350-041 to Step 5	KJ/JLM	

**RELEASED**  
05/03/07

Rel 00307  
AL  
05/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 30, 2005  
02:06 pm

Work Order No	: 0023716	Department Code:	
Project Name	: D350-721-041	Burden Flags	: NNNNNNNN
Project For	: WK528	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *D350-721-041	Invoice Number	:
Description	: Heli-Utility-Basket, Lwt	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 06-30-05		
Est Finish Date	: 07-15-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

5/28

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23716
<b>Description:</b> Basket Lid Assembly	<b>Part Number:</b>	D3325-041
<b>Dwg:</b> D3325 Rev. <i>AB 1/16/05</i>	<b>Qty:</b>	1
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler <b>Dwg not required</b>	AB	05.06.30	1																				
2	WS	Cut tubes as per Dwg D3325 Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall (M4130N-TS0.500W.035) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3325-1</td><td>End Tube</td><td>M17679</td></tr><tr><td>3</td><td>D3325-3</td><td>Interior Tube</td><td>M17679</td></tr><tr><td>2</td><td>D3325-5</td><td>Full Length Tube</td><td>M17679</td></tr></table> <b>Identify parts appropriately</b>	Qty	Part Number	Description	Batch	2	D3325-1	End Tube	M17679	3	D3325-3	Interior Tube	M17679	2	D3325-5	Full Length Tube	M17679	AB	05/07/07	1				
Qty	Part Number	Description	Batch																						
2	D3325-1	End Tube	M17679																						
3	D3325-3	Interior Tube	M17679																						
2	D3325-5	Full Length Tube	M17679																						
3	WS	<b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3328-1</td><td>Hinge Plate</td><td>B23661</td></tr><tr><td>2</td><td>D3349-1</td><td>Spacer Bushing</td><td>B23025</td></tr><tr><td>1</td><td>D3352-1</td><td>Label Plate</td><td>B23028</td></tr><tr><td>2</td><td>D3367-1</td><td>Mounting Bracket</td><td>B23660</td></tr></table>	Qty	Part Number	Description	Batch	2	D3328-1	Hinge Plate	B23661	2	D3349-1	Spacer Bushing	B23025	1	D3352-1	Label Plate	B23028	2	D3367-1	Mounting Bracket	B23660	AB	05/07/07	1
Qty	Part Number	Description	Batch																						
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2	D3349-1	Spacer Bushing	B23025																						
1	D3352-1	Label Plate	B23028																						
2	D3367-1	Mounting Bracket	B23660																						
4	WS	Remove all markings from material	AB	05/07/07	1																				
5	WS	Drill and Weld as per Dwg D3325 & QSI 004 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>Steel Rod</td><td>M9430</td></tr></table>	Qty	Part Number	Description	Batch	A/R	N/A	Steel Rod	M9430	AB	05/07/19	1												
Qty	Part Number	Description	Batch																						
A/R	N/A	Steel Rod	M9430																						
6	WS	Deburr as required	AB	05/07/19	1																				
7	QC9/6	Inspect welding and dimensions	AB	05-07-19	1																				
8	WS	Take traveler to KP	FC	05.07.26	1																				
9	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3	FC	05.07.26	1																				
10	QC3	Inspect Powder Coat	AB	05.07.26	1																				
11	FP	To GA for assembly	AB	05.07.26	1																				

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
*[Signature]* 05.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

5/28

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23716
<b>Description:</b> Basket Base Assembly	<b>Part Number:</b>	D3324-041
<b>Dwg:</b> D3324 Rev. <i>AB 05.05.02</i>	<b>Qty:</b>	1
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																								
1	DC	Issue Traveler <b>Dwg not required</b>	AB	05.06.30	1																								
2	WS	Cut tubes as per Dwg D3324 Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall (M4130N-TS0.500W.035) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>3</td><td>D3324-1</td><td>Bottom Tube</td><td>M16550</td></tr><tr><td>4</td><td>D3324-3</td><td>Full Length Tube</td><td>M16550</td></tr><tr><td>2</td><td>D3324-5</td><td>Top End Tube</td><td>M17679</td></tr><tr><td>2</td><td>D3324-7</td><td>Bottom EndTube</td><td>M17679</td></tr><tr><td>10</td><td>D3324-9</td><td>Vertical Tube</td><td>M17679</td></tr></table> <b>Identify parts appropriately</b>	Qty	Part Number	Description	Batch	3	D3324-1	Bottom Tube	M16550	4	D3324-3	Full Length Tube	M16550	2	D3324-5	Top End Tube	M17679	2	D3324-7	Bottom EndTube	M17679	10	D3324-9	Vertical Tube	M17679	AB	05/07/02	1
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8	WS	Take traveler D350-721-041 to KP	FL	05 07 26	1																								
9	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3	FL	05 07 26	1																								
10	QC3	Inspect Powder Coat	AB	05 07 26	1																								
11	FP	To GA for assembly	AB	05 07 26	1																								

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	<i>AB</i>

RELEASED  
05-02-14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_